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(19) (CA) **CANADIAN PATENT** (12)

(54) Anti-Reflection Optical Article and Process of Producing
the Same

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S P E C I F I C A T I O N

BACKGROUND OF THE INVENTION

I. Field of the Invention

5 This invention relates to an anti-reflection optical article with an excellent scratch resistance, dyeability, impact resistance, chemical resistance, flexibility and weatherability. The anti-reflection optical article of the present invention is suited for optics, for example, optical lenses such as lenses of spectacles and cameras.

10 II. Description of the Prior Art

When a thing is seen through a transparent material, if reflected rays are strong and a reflected image is clear, seeing is disturbed, and reflected image such as so-called ghosts or flares are formed to give an
15 unpleasant feel to eyes. In case of using a looking glass, the content cannot be clearly seen because of rays reflected from the glass surface.

There is also a problem that the optical articles have a tendency to attract dust. Since the attraction is
20 due to an electrostatic force retained by the optical article, the dust is hardly removed by simply wiping the optical article.

A number of measures have been proposed for preventing the reflection, and some of them are currently
25 used. Obtaining an anti-reflection effect by applying a liquid composition to a transparent substrate is disclosed, for example, in USP 4,361,598, Japanese Patent



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Disclosure (Kokai) Nos. 167448/83, 211701/83, 43601/83
and 49501/84.

However, the optical articles disclosed in Japanese
Patent Disclosure (Kokai) Nos. 167448/83 and 211701/83
5 are made of glass, so that they cannot be dyed. Not only
in view of the dyeability, but also in view of the
lightness, flexibility and processability, plastic
substrates are desired.

Optical articles having a plastic substrate are
10 disclosed, for example, in USP 4,590,117 and Japanese
Patent Disclosure (Kokai) Nos. 43601/83 and 49501/84.
However, those disclosed in these references employ a
structure including two or more layers, so that the
productivity, reproducibility and uniformity of the plane
15 are not good.

It is also known that a fluorine-containing
organopolysiloxane-based thin film is formed on the
surface of an optical article for preventing the
reflection (Japanese Patent Disclosure (Kokai) No.
20 40845/85).

On the other hand, for the prevention of attachment
of dust to the optical article, charging-preventing
agents comprising a surface active agent, which are to be
applied to the optical article are commercially
25 available. However, these agents show their effect only
temporarily.

As to the prevention of charging of plastic mold

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articles, various methods are known such as, for example, disclosed in Japanese Patent Publication (Kokoku) Nos. 15494/80 and 21628/85.

SUMMARY OF THE INVENTION

5 The object of the present invention is to provide an anti-reflection optical article having an excellent anti-reflection property, scratch resistance, dyeability, impact resistance, chemical resistance, flexibility and weatherability.

10 The above object and other objects of the present invention may be accomplished by providing an anti-reflection optical article comprising a transparent plastic substrate; a hard coat film formed on a surface of the substrate, the film having an index of refraction
15 of not less than 1.52; and a fluorine-containing organopolysiloxane-based film with a thickness of 10 nm to 500 nm, which has an index of refraction lower than that of the hard coat film by not less than 0.02, and which is formed on the hard coat film.

20 This invention further provides a process of producing the above-described anti-reflection optical article, comprising the steps of providing the transparent plastic substrate on which the hard coat film having an index of refraction of not less than 1.52 is
25 formed; applying a liquid coating composition comprising a fluorine-containing organic silicon compound and/or a hydrolysate thereof, on the hard coat film; and curing

the applied composition to form the fluorine-containing organopolysiloxane-based film with an index of refraction lower than that of the hard coat film by not less than 0.02.

5 The anti-reflection optical article of the present invention has an excellent anti-reflection property, and a uniform reflection color may be imparted. Since the surface of the optical article of the present invention is hard, it has an excellent scratch resistance, impact
10 resistance and durability. The optical article of the present invention may be easily dyed and the dying speed is high. Further, the outer appearance after dying is nice. The surface of the optical article of the present invention is smooth, so that it is hardly scratched.

15 DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

As stated above, the anti-reflection optical article of the present invention includes a transparent plastic substrate. Any plastic may be used for forming the substrate. Preferred example of the plastics which may
20 be used for forming the substrate includes acrylic resins, polystyrenes, polycarbonates, diethyleneglycolbisallylcarbonate polymers, di-(meta)-methacrylate polymers of (halogenated)bisphenol A and copolymers thereof, urethane-modified
25 (meta)acrylate polymers of (halogenated)bisphenol A and copolymers thereof.

A hard coat film is formed on a surface of the

substrate. The term "hard coat film" herein used means a film having a pencil hardness of 4H or more as determined by the method according to JIS K5400.

5 The hard coat film has an index of refraction of not less than 1.52. If the index of refraction is less than 1.52, the anti-reflection property may not be obtained. In view of further promoting the anti-reflection property, it is preferred that the index of refraction of the hard coat film be not less than 1.54.

10 Any material may be used for forming the hard coat film as long as it has a pencil hardness of not less than 4H and an index of refraction of not less than 1.52. Preferred examples of the materials which may be used for forming the hard coat film may include organic resins
15 such as acrylic resin, polyester resin, organopolysiloxane resin, polyurethane, cellulose derivatives, epoxide polymer, nylon resin, melamine resin and inorganic compounds such as inorganic oxides such as titanium oxide and zirconium oxide obtained from metal
20 alkoxide or metal chelate.

It should be noted, however, in view of further increasing the surface hardness and further promoting the adhesivity with the fluorine-containing organopolysiloxane-based film, and in view of the
25 feasibility to give the high index of refraction, it is preferred that the hard coat film contain inorganic microparticles having a high index of refraction.

Preferred examples of the microparticles to be contained in the hard coat film may include microparticles of oxides of metals such as tantalum, aluminum, titanium, zirconium, tin and antimony. These
5 oxides are preferred since they not only give a high index of refraction, but also give a great hardness and high transparency. Among the above-mentioned oxides, oxides of tantalum, zirconium, titanium and antimony are especially preferred in view of their stability. These
10 microparticles may be used individually or in combination. The oxide may be a composite oxide containing silicon or the like.

The inorganic microparticles preferably has a mean particle size of about 1 - 300 nm, more preferably about
15 5 - 200 nm, in view of not degrading the transparency of the hard coat film.

If the content of the inorganic microparticles is too small, the effect of the microparticles may not be shown, and if its content is too great, the hard coat
20 film may have a tendency to be cracked. Therefore, the content of the inorganic microparticles in the hard coat film is preferably 10 - 75% by weight, and more preferably 15 - 60% by weight.

The thickness of the hard coat film varies
25 depending on the plastic material forming the transparent substrate and should be selected to have a pencil hardness of not less than 4H. If the hard coat film is

too thin, it is difficult to obtain a sufficient hardness and a sufficient dyeability, and if the hard coat film is too thick, it is difficult to obtain a uniform film and the impact resistance may be degraded. Thus, thickness
5 of the hard coat film is usually 0.5 μm to 20 μm .

The hard coat film may be formed on the substrate by applying a liquid coating composition comprising the above-described resin on the plastic transparent substrate and by curing the applied composition.

10 A fluorine-containing organopolysiloxane-based film (hereinafter referred to as "top film" for short) with a thickness of 10 - 500 nm and an index of refraction which is lower than that of the hard coat film by 0.02 or more is formed on the hard coat film.

15 The thickness of the top film is 10 nm to 500 nm, preferably 50 nm to 300 nm. If the thickness of the top film is smaller than 10 nm, sufficient anti-reflection property and a sufficient surface hardness may not be obtained. If the thickness of the top film is greater
20 than 500 nm, anti-reflection effect may not be obtained.

Preferred top film is one obtained by applying to the hard coat film a liquid composition comprising a fluorine-containing organic silicon compound of the formula (I) or a hydrolysate thereof:



wherein R^1 is a $\text{C}_1 - \text{C}_{20}$ fluorine-containing alkyl group which may contain one or more ether bonds and/or ester

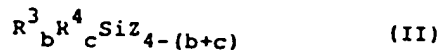
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bonds; Q is a divalent organic group; X is a C₁ - C₄ alkyl group; Y is a halogen, alkoxy or RCOO⁻ group (wherein R is hydrogen or a C₁ - C₄ alkyl group); and a is an integer of 0 or 1.

5 Preferred examples of the fluorine-containing compound of the formula (I) may include 3,3,3-trifluoropropyltrialkoxysilane, 3,3,3-trifluoropropylmethyldialkoxysilane and 3-trifluoroacetoxypropyltrialkoxysilane.

10 It is preferred that the compound expressed by the formula (I) be contained in the top film in the amount of at least 10% by weight or in cases where the index of refraction of the hard coat film is not so high, in the amount of at least 15% by weight.

15 To further improve the abrasion resistance, scratch resistance, impact resistance, chemical resistance, flexibility, light resistance and weatherability of the combination of the hard coat film and the top film, it is preferred that one or more of organic silicon compounds 20 of the formula (II) be contained in the top film along with the above-described fluorine-containing organopolysiloxane of the formula (I).



wherein R³ and R⁴ are independently alkyl, alkenyl or 25 aryl group or a hydrocarbon group containing halogen, epoxy, glycidoxy, amino, mercapto, methacryloxy or cyano group; Z is a hydrolyzable group; and b and c

independently means 1 or 0.

- Preferred examples of the compounds represented by the formula (II) may include tetraalkoxysilanes such as methyl silicate, ethyl silicate, n-propyl silicate, i-propyl silicate, n-butyl silicate, sec-butyl silicate and t-butyl silicate and hydrolysates thereof; trialkoxysilanes, triacyloxysilanes and triphenoxysilanes such as methyltrimethoxysilane, methyltriethoxysilane, methyltrimethoxyethoxysilane, methyltriacetoxysilane, methyltripropoxysilane, methyltributoxysilane, ethyltrimethoxysilane, ethyltriethoxysilane, vinyltrimethoxysilane, vinyltriethoxysilane, vinyltriacetoxysilane, vinyltrimethoxyethoxysilane, phenyltrimethoxysilane, phenyltriethoxysilane, phenyltriacetoxysilane, γ -chloropropyltrimethoxysilane, δ -chloropropyltriethoxysilane, δ -chloropropyltriacetoxysilane, γ -methacryloxypropyltrimethoxysilane, γ -aminopropyltrimethoxysilane, γ -aminopropyltriethoxysilane, γ -mercaptopropyltrimethoxysilane, δ -mercaptopropyltriethoxysilane, N- β -(aminoethyl)- δ -aminopropyltrimethoxysilane, ϕ -cyanoethyltriethoxysilane, methyltriphenoxysilane, chloromethyltrimethoxysilane, chloromethyltriethoxysilane, glycidoxymethyltrimethoxysilane,

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- glycidoxymethyltriethoxysilane,
- α -glycidoxyethyltrimethoxysilane,
- α -glycidoxyethyltriethoxysilane,
- β -glycidoxyethyltrimethoxysilane,
- 5 β -glycidoxyethyltriethoxysilane,
- α -glycidoxypropyltrimethoxysilane,
- α -glycidoxypropyltriethoxysilane,
- β -glycidoxypropyltrimethoxysilane,
- β -glycidoxypropyltriethoxysilane,
- 10 δ -glycidoxypropyltrimethoxysilane,
- δ -glycidoxypropyltriethoxysilane,
- δ -glycidoxypropyltripropoxysilane,
- δ -glycidoxypropyltributoxysilane,
- δ -glycidoxypropyltrimethoxyethoxysilane,
- 15 δ -glycidoxypropyltriphenoxysilane,
- α -glycidoxybutyltrimethoxysilane,
- α -glycidoxybutyltriethoxysilane,
- β -glycidoxybutyltrimethoxysilane,
- β -glycidoxybutyltriethoxysilane,
- 20 δ -glycidoxybutyltriethoxysilane,
- δ -glycidoxybutyltriethoxysilane,
- δ -glycidoxybutyltrimethoxysilane,
- δ -glycidoxybutyltriethoxysilane,
- (3,4-epoxycyclohexyl)methyltrimethoxysilane,
- 25 (3,4-epoxycyclohexyl)methyltriethoxysilane,
- β -(3,4-epoxycyclohexyl)ethyltrimethoxysilane,
- β -(3,4-epoxycyclohexyl)ethyltriethoxysilane,

- β -(3,4-epoxycyclohexyl)ethyltripropoxysilane,
 β -(3,4-epoxycyclohexyl)ethyltributoxysilane,
 β -(3,4-epoxycyclohexyl)ethyltrimethoxyethoxysilane,
 β -(3,4-epoxycyclohexyl)ethyltriphenoxysilane,
5 γ -(3,4-epoxycyclohexyl)propyltrimethoxysilane,
 γ -(3,4-epoxycyclohexyl)propyltriethoxysilane,
 δ -(3,4-epoxycyclohexyl)butyltrimethoxysilane and
 δ -(3,4-epoxycyclohexyl)butyltriethoxysilane as well as
hydrolysates thereof; and dialkoxysilanes,
10 diphenoxysilanes and diacyloxysilanes such as
dimethyldiemthoxysilane, phenylmethyldiemthoxysilane,
dimethyldiethoxysilane, phenylmethyldiethoxysilane,
 γ -chloropropylmethyldimethoxysilane,
 γ -chloropropylmethyldiethoxysilane,
15 dimethyldiacetoxysilane,
 γ -methacryloxypropylmethyldimethoxysilane,
 γ -methacryloxypropylmethyldiethoxysilane,
 γ -mercaptopropylmethyldimethoxysilane,
 γ -mercaptopropylmethyldiethoxysilane,
20 γ -aminopropylmethyldimethoxysilane,
 γ -aminopropylmethyldiethoxysilane,
methylvinylmethyldimethoxysilane, methylvinylmethyldiethoxysilane,
glycidoxymethylmethyldimethoxysilane,
glycidoxymethylmethyldiethoxysilane,
25 α -glycidoxyethylmethyldimethoxysilane,
 α -glycidoxyethylmethyldiethoxysilane,
 β -glycidoxyethylmethyldimethoxysilane,

- β-glycidoxyethylmethyldiethoxysilane,
α-glycidoxypropylmethyldimethoxysilane,
α-glycidoxypropylmethyldiethoxysilane,
β-glycidoxypropylmethyldiemthoxysilane,
5 β-glycidoxypropylmethyldiethoxysilane,
δ-glycidoxypropylmethyldimethoxysilane,
δ-glycidoxypropylmethyldiethoxysilane,
δ-glycidoxypropylmethyldipropoxysilane,
δ-glycidoxypropylmethyldibutoxysilane,
10 δ-glycidoxypropylmethyldimethoxyethoxysilane,
γ-glycidoxypropylmethyldiphenoxysilane,
δ-glycidoxypropylmethyldiacetoxysilane,
γ-glycidoxypropylethyldimethoxysilane,
γ-glycidoxypropylethyldiethoxysilane,
15 γ-glycidoxypropylvinylmethoxysilane,
γ-glycidoxypropylvinylmethoxysilane,
δ-glycidoxypropylphenyldimethoxysilane and
δ-glycidoxypropylphenyldiethoxysilane, as well as
hydrolysates thereof.

20 For the purpose of giving dyeability, the organic silicon compounds having an epoxy group or a glycidoxy group are preferred.

To lower the curing temperature and to promote the curing, it is preferred that the fluorine-containing
25 organic silicon compound of the formula (I) or the mixture of the fluorine-containing silicon compound and the organic silicon compound of the formula (II) be used

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after being hydrolyzed.

Hydrolysis may be conducted by adding pure water or aqueous solution of an acid such as hydrochloric acid, acetic acid and sulfuric acid to the organic silicon
5 compound and by stirring the resulting mixture. By controlling the amount of the water or the aqueous acid solution to be added, the degree of hydrolysis may easily be controlled. In view of the promotion of the curing, it is preferred that the water or the aqueous acid
10 solution be added in the amount of not less than the equimolar of the -Y group in the formula (I) and not more than three times of the mole number of the -Y group.

Although the hydrolysis may be conducted without using a solvent because alcohols and the like are
15 generated, for the purpose of conducting the hydrolysis uniformly, the hydrolysis may be conducted after mixing the organic silicon compounds with a solvent. Further, it is possible to partly remove the alcohols and the like by heating and/or by reduced pressure, and it is also
20 possible to add an appropriate solvent after a portion of the alcohols and the like are removed.

Preferred examples of the solvent may include alcohols such as ethanol, esters such as butyl acetate, ethers such as diethylether, dioxane, ketones such as
25 methyl-isobutyl ketone, halogenated hydrocarbons such as 1,1,2-trichloroethane, and aromatic hydrocarbons such as toluene and xylene. Those solvents may be used

individually or in combination. To promote the hydrolysis reaction, the mixture may be heated to a temperature higher than room temperature. In contrast, the mixture may be cooled to a temperature lower than room temperature in order to conduct the hydrolysis reaction without causing preliminary polymerization.

When applying the hard coat film on the plastic transparent substrate, or when applying the top film on the hard coat film, the surface of the transparent substrate or the hard coat film is preferred to be subjected to a pretreatment for the purpose of cleaning the surface, promoting the adhesivity, and promoting water resistance. Effective pretreatment may include activated gas treatment and chemical treatment.

Activated gas treatment means a treatment with ions, electrons or excited gas which are generated under the normal pressure or under reduced pressure. The activated gas may be generated by, for example, corona discharge and high voltage discharge by using direct electric current, low frequency wave, high frequency wave or microwave under reduced pressure. The treatment with the low temperature plasma obtained by high frequency wave discharge in reduced pressure and corona discharge treatment are especially preferred.

Examples of the gas to be used herein may include oxygen, nitrogen, hydrogen, carbon dioxide, sulfur dioxide, helium, neon, argon, Freon (tradename of Du

Pont), water vapor, ammonia, carbon monoxide, chlorine, nitrogen monoxide and nitrogen dioxide.

These gases may be used individually or in combination. In view of improving the adhesivity, a gas
5 containing oxygen is preferred and air may be used advantageously. Pure oxygen gas is still more preferred. For the purpose of improving the adhesivity, the activated gas treatment may be conducted under an elevated temperature.

10 On the other hand, examples of the chemical treatment may include alkali treatment such as by sodium hydroxide, acid treatment such as by hydrochloric acid, sulfuric acid, potassium permanganate and potassium dichromate, and treatment with an organic solvent having
15 an aromatic ring.

The above pretreatments may be conducted in combination continuously or stepwise.

For the curing of the liquid composition for forming the hard coat film or the top film, curing agent may be
20 used to promote the curing and enabling the curing to be conducted under a low temperature. As the curing agent, various curing agents for epoxy resins and various curing agents for organic silicon resins may be used.

Examples of the curing agents may include various
25 organic acids and acid anhydrides thereof, nitrogen-containing organic compounds, various metal complexes, metal alkoxides, and various salts such as

organic carboxylates and carbonates of alkali metals.

The curing agents may be used individually or in combination.

Among these curing agents, in view of the stability
5 of the composition and coloring of the coated film,
aluminum chelates represented by the formula (III) are
especially preferred.



wherein X is OL (L is a $\text{C}_1 - \text{C}_4$ alkyl); Y is a ligand
10 selected from the group consisting of $\text{M}^1\text{COCH}_2\text{COM}^2$ (M^1 and
 M^2 are independently a $\text{C}_1 - \text{C}_4$ alkyl) and $\text{M}^3\text{COCH}_2\text{COOM}^4$
(M^3 and M^4 are independently a $\text{C}_1 - \text{C}_4$ alkyl); n is 0, 1
or 2.

Among those represented by the formula (III),
15 especially preferred are aluminum acetylacetonate,
aluminum bisethylacetoacetate monoacetylacetonate,
aluminum-di-n-butoxide-monoethylaceto acetate and
aluminum-di-iso-propoxide-monomethylaceto acetate, in
view of the solubility, stability and curing power as a
20 curing agent. These compounds may be used individually
or in combination.

To improve the flow of the applied composition, and
to improve the smoothness of the surface of the film to
reduce the friction coefficient of the film surface, a
25 surface active agent may be incorporated in the
composition to be applied. Examples of the surface
active agent may include block or graft polymers of

dimethylsiloxane and alkylene oxide; and fluorine-based surface active agent.

5 Dyes or pigments may be added to the composition for coloring the film. Further, fillers and organic polymers may be incorporated in the composition to improve the applicability of the composition, intimacy to the substrate or film and to improve the physical properties of the film. Still further, to improve the weatherability, ultraviolet ray absorbing agent may be
10 contained in the composition. To improve the heat degradation resistance, anti-oxidant may be contained in the composition.

15 To increase the surface hardness and to prevent the electric charging, silica sol of a large molecular weight silic acid anhydride in the form of a colloidal dispersion in water and/or an organic solvent such as ethanol may preferably be added to the composition. In particular, when the silica sol is added to the top film, the abrasion resistance of the top film is improved very
20 much such that the top film may be resistant against the abrasion by Carborundum (tradename of Carborundum) powder. Preferred examples of the silicic acid may include colloidal silica of which average radius is 0.5 - 100 nm and which is acidic.

25 To promote the dyeability, various epoxy resins, melamine resins and nylon resins may be added to the composition.

The above-described additives may be added to the liquid composition in the amount of, for example, 5 to 70 wt % based on dry weight.

When applying the coating composition, the
5 composition may be diluted with a diluent for controlling the thickness of the applied coating and for making the application operation easy. Preferred examples of the diluent may include water, alcohols such as ethanol, esters such as butyl acetate, ethers such as
10 diethyleneglycoldimethyl ether, ketones such as methyl-isobutyl ketone and halogenated hydrocarbons such as 1,1,2-trichloroethane.

The reflectance of the surface of the optical article of the present invention, which surface requires
15 anti-reflection property, is not more than 2.7%. In cases where the anti-reflection property is required for both surfaces of the optical article, such as in case of the lens of spectacles, the total reflectance of the both surfaces is not more than 5.4%, i.e., the transmittance
20 of the whole optical article is not less than 94.6%.

In a preferred embodiment of the present invention, the electric charging is reduced while keeping the anti-reflection property and other excellent properties of the above-described optical article of the present
25 invention. In this embodiment, the average fluorine to silicon ratio (F/Si) by weight in the entire top film is 0.02 to 10, and the ratio in the uppermost region of the

top film is less than 80% that of the entire top film.
The term "uppermost region" herein means the region from
the surface to a depth of 1 nm to 30 nm from the surface.
If the fluorine to silicon ratio is less than 0.02,
5 anti-reflection property may be degraded, and if it is
more than 10, the hardness of the top film may be
reduced. If the fluorine to silicon ratio in the
uppermost region in the top film is not less than 80%,
the prevention of electric charging may not be
10 accomplished.

This structure of the top film may be obtained by,
for example, subjecting the top film to the
above-mentioned activated gas treatment. The conditions
of the activated gas treatment may be appropriately
15 selected by those skilled in the art in view of the
required anti-static property.

It is also useful for preventing the electric
charging to form on the top film a second
fluorine-containing organopolysiloxane-based film having
20 a F/Si ratio by weight of less than 80% that of the top
layer. By so doing, the same effect brought about by
setting the F/Si ratio by weight in the uppermost region
of the top layer to less than 80% may be obtained. The
thickness of the second film is preferably 1 nm to 30 nm
25 because a film thinner than 1 nm is difficult to prepare,
and if the film is thicker than 30 nm, the
anti-reflection property may be degraded.

The second fluorine-containing organopolysiloxane film may be formed in a similar manner as in forming the top film, after chemical treatment of the top film. Examples of the chemical treatment may include treatments
5 with alkali such as sodium hydroxide; with acid such as hydrochloric acid, sulfuric acid, potassium permanganate and potassium dichromate; and with organic solvent having an aromatic ring such as toluene, xylene, benzyl alcohol. The chemical treatment may be conducted individually or
10 in combination continuously or stepwise.

The fluorine/silicon weight ratio may be determined by a well-known X-ray photoelectron analysis (ESCA).

Since the anti-reflection optical article of the present invention has an excellent anti-reflection
15 property, durable hard surface, dyeability and anti-static property, it is suited for use not only as a lens of sunglasses and as an ophthalmic lens, but also as a camera lens and as a binocular lens.

The present invention will now be described by way
20 of examples. The examples are presented for the purpose of illustration only, and they should not be interpreted as limiting the scope of the invention in any way.

Example 1, Comparative Example 1

(1) Preparation of Transparent Plastic Substrate

25 A transparent plastic substrate was obtained by cast polymerization of 270 parts by weight of a polyfunctional acrylate monomer and 30 parts by weight of styrene using

di-isopropylperoxide as an initiator, the polyfunctional acrylate monomer having 0.9 mole of hexamethylenediisocyanate per 1 mole of hydroxide group-containing compound prepared by bonding via ester bond tetrabromobisphenol A having 2 moles of ethylene oxide adduct with 1 mole of acrylic acid. The index of refraction of the thus obtained resin was 1.61.

(2) Preparation of Coating Composition for Forming Hard Coat Film

(a) Preparation of Hydrolysate of γ -glycidoxypyrroltrimethoxysilane

To a reactor with a rotating member of a magnetic stirrer, 95.3 g of γ -glycidoxypyrroltrimethoxysilane was fed. While keeping the temperature of the liquid at 10°C, 21.8 g of 0.01 N aqueous hydrochloric acid was added dropwise while stirring the mixture with a magnetic stirrer. After finishing the dropwise addition of the hydrochloric acid, cooling is stopped to obtain a hydrolysate of γ -glycidoxypyrroltrimethoxysilane.

(b) Preparation of Coating Composition

To the thus obtained hydrolysate, were added 216 g of dimethylformamide, 0.5 g of fluorine-based surface active agent and 67.5 g of bisphenol A type epoxy resin (commercially available from Shell Chemical Co. under the ~~trade-mark~~ ~~tradename~~ of Epicoat 827), and the mixture was stirred. To the mixture, were added 270 g of colloidal antimony pentaoxide sol (mean particle size of 60 nm, commercially

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available from Nissan Chemical Industries, Ltd., Tokyo, Japan, under the ~~trade name~~ ^{trade mark} of Antimony Sol A-2550) and 13.5 g of aluminum acetylacetonate, and then 1.1 g of acetylacetonate Cu(II) as a transition metal compound was added. The resulting mixture was well stirred to obtain a coating composition for forming the hard coat film.

(3) Preparation of Coating Composition for Forming Fluorine-Containing Organopolysiloxane Film

(a) Preparation of Hydrolysate

To a reactor with a rotating member, 4.9 g of methyltrimethoxysilane and 3.5 g of 3,3,3-trifluoropropyltrimethoxysilane were fed. While keeping the temperature of the liquid at 10°C, 2.8 g of 0.01 N aqueous hydrochloric acid was added dropwise while stirring the mixture with a magnetic stirrer. After finishing the addition of the hydrochloric acid, cooling is stopped to obtain a hydrolysate.

(b) To the thus obtained hydrolysate, were added 56.0 g of n-propylalcohol, 24.0 g of distilled water, 7.5 g of ethylCellosolve, 1.0 g of silicone-based surface active agent in n-propylalcohol in a concentration of 5% by weight, and 0.24 g of aluminum acetylacetonate. The mixture was well stirred to obtain a coating composition.

(4) Preparation of Anti-Reflection Optical Article

The transparent plastic substance obtained in (1) was coated with the coating composition obtained in (2) by dipping the substrate in the composition. The thus

coated lens was subjected to a preliminary curing at 110°C for 12 minutes, and then to a curing treatment at 110°C for 4 hours. The thus formed hard coat film has an index of refraction of 1.58, pencil hardness of 8H and a thickness of 2.8 μm .

The thus obtained cured lens was subjected to a pretreatment using a surface treatment plasma-generating apparatus (PR501A, commercially available from Yamato Kagaku Co., Japan) at an oxygen flow of 100 ml/min. and at an output power of 50W for 1 minute.

Then the coating composition obtained in (3) (b) was applied on the pretreated hard coat film by spin coating with a rotation speed of 3,500 rpm and a rotation time of 30 seconds. After the spin coating, the coated composition was subjected to a preliminary curing at 82°C for 12 minutes and then to a curing treatment at 93°C for 4 hours to form a fluorine-containing polyorganosiloxane film. The thus formed film has a thickness of 100 nm and an index of refraction of 1.39.

The total light transmittance of the thus prepared optical article was 96.1%.

For comparison, an optical article was prepared in the same manner except that the hard coat film was omitted.

The obtained optical articles were tested for their properties as described in (5) below. The results are shown in the following Table 1.

T a b l e 1

	Example 1	Comparative Ex. 1
Total Light Transmittance (%)	95.1	96.3
Dyeability (%)	40.0	90.2
5 Appearance after Dying	good	-
Steel Wool Hardness	A	C

As is seen from Table 1, the anti-reflection lens having the hard coat film was satisfactory in all of the anti-reflection property, dyeability and surface hardness, while the one having no hard coat film had insufficient dyeability and surface hardness and cannot be used practically.

(5) Testing Methods

15 (5)-1 Dyeability

The dyeability is expressed in terms of the total light transmittance of the article after dipping the article in a disperse dye (mixture of 3 colors of red, blue and yellow) at 93°C for 15 minutes.

20 (5)-2 Appearance After Dying

Appearance was examined by gross examination with eyes.

Good: Lens was uniformly dyed.

Bad: Lens was non-uniformly dyed.

25 (5)-2 Steel Wool Hardness

The coating film was abraded with #0000 steel wool, and the degree of scratching of the film was examined by

gross examination. The evaluation criteria are as follows:

A: No scratch are given even by a strong abrasion.

B: Scratches are given by a strong abrasion.

5 C: Scratches are given by a weak abrasion.

Examples 2 - 4, Comparative Example 2

A A diethyleneglycolbisallyl carbonate polymer lens *
(diameter of 71 mm, thickness of 2.1 mm, CR-39 Planolens, commercially available from Pittsburgh Plate Glass)
10 having an index of refraction of 1.50 was used as the plastic transparent substrate after dipping in aqueous sodium hydroxide solution with a concentration of 20 wt % and washing. As a coating composition for forming the fluorine-containing organopolysiloxane film, compositions
15 similar to that used in Example 1 but having a varying ratio (shown in Table 2) of methyltrimethoxysilane to 3,3,3-trifluoropropyltrimethoxysilane and
γ-glycidoxypropyltrimethoxysilane were used. Optical
articles were prepared in the same manner as in Example
20 1.

For comparison, an optical article was prepared in the same manner except that the hard coat film was omitted.

25 The results are shown in Table 2. As is apparent from Table 2, the optical article having no hard coat film (Comparative Example 2) had very low surface hardness.

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TABLE 2

	3,3,3-trifluorotri- methoxysilane (parts by weight)	Methyltrimethoxy- silane (parts by weight)	γ-glycidypropyl- trimethoxysilane (parts by weight)	Total Light Transmittance (%)	Steel Wool Hardness	Dyeability (%)	Top Film	
							Film Thickness	Index of Refraction
Example 2	50	50	0	96.4	A	40.0	100	1.39
Example 3	41	41	18	96.6	A	35.7	110	1.40
Example 4	65	0	35	96.1	B	15.6	90	1.39
Comparative Example 2	50	50	0	95.4	C	45.3	100	1.39

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Examples 5 and 6

The optical articles obtained in Examples 1 and 2 were subjected to an anti-static treatment by using a surface treatment plasma-generating apparatus (PR501A, commercially available from Yamato Kagaku Co., Japan) with 100 ml/min. of oxygen flow and with an output power of 50W for 3 minutes.

The fluorine/silicon ratio (F/Si) by weight of the thus treated top film was 0.04/1 in the uppermost region thereof. The average fluorine/silicon ratio in the entire top film was 0.08/1.

The total light transmittance of the optical article was 96.1% (Example 5) and 96.4% (Example 6). In both examples, the half life of the voltage of the electric charge as determined by the method described below was not more than 1 second, and the punch dust was not attached at all to the article from the beginning in the punch dust test hereinafter described.

For comparison, the optical articles which were not subjected to the anti-static treatment were tested for their half life of the voltage of the electric charge and were subjected to punch dust test. The fluorine/silicon ratio in the top film of the articles was 0.08/1 by weight. The half life of the voltage of the electric charge was 121 seconds (untreated article of Example 5) or 360 seconds or more (untreated article of Example 6), and the results of the punch dust test were 20 and 30,

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respectively. Thus, the untreated optical articles were likely to be charged.

The methods of determining the half life and conducting the punch dust test were as follows:

5 (A) Half Life of Voltage of Electric Charge

Using a static honest meter, the articles were charged at 10 kV, 1000 rpm at 20°C, 65%RH, and then the half life of the voltage of the electric charge was determined.

10 (B) Punch Dust Test

At 20 - 25°C, 50 - 70%RH, the optical articles were wiped with a skin of deer to electrically charge the articles. On the other hand, punch dust was scattered on a desk. The charged optical article was brought to close
15 to the punch dust to a distance of 1 - 2 cm from the dust. The optical article was fixed in the same position for 30 minutes, and the number of dust retained by the article without falling down was counted.

Example 7

20 (1) Preparation of Fluorine-Containing Composition

(a) Preparation of Hydrolysate

To a reactor with a rotating member of a magnetic stirrer, 5.2 g of γ -glycidoxypropyltrimethoxysilane and 3.1 g of 3,3,3-trifluoropropyltrimethoxysilane were fed.
25 While keeping the temperature of the liquid at 30°C and stirring the liquid with the magnetic stirrer, 2.8 g of 0.01 N aqueous hydrochloric acid was added dropwise.

After addition of the hydrochloric acid, the mixture was stirred for 10 minutes at room temperature to obtain a hydrolysate.

(b) Preparation of Coating Composition

5 To the thus obtained hydrolysate, were added 141.6 g of n-propyl alcohol, 60.7 g of distilled water and 18.8 g of ethylCellosolve and the mixture was stirred. To the resulting mixture, were added 16.0 g of methanol silica sol, 2.2 g of silicone-based surface active agent in
10 n-propyl alcohol at a concentration of 5% by weight, and 0.6 g of aluminum acetylacetonate. The mixture was well stirred to obtain a coating composition.

(2) Preparation of Anti-Reflection Article

An article was prepared in the same manner as in
15 Example 1 using the substrate obtained in Example 1 (1) and the coating composition obtained in Example 1 (2), and the resulting article was subjected to a plasma treatment at 200 ml/min. of oxygen flow and at an output power of 50W for 1 minute.

20 Then the coating composition obtained in this example (1) (b) was coated on the thus prepared article by a spin coating method employing a rotation speed of 3,500 rpm and rotation time of 30 seconds. After coating the composition, the article was subjected to a preliminary
25 curing at 82°C for 12 minutes and then to a curing treatment at 110°C for 4 hours to obtain an anti-reflection optical lens.

The total light transmittance of the thus obtained optical article was 95.2%.

The properties of the thus formed lens were tested as in Example 1-(5). The results are as follows:

5 Dyeability (%): 37.0

Appearance after Dying: good

Steel Wool Hardness: A

(3) Anti-Static Treatment

10 The optical article obtained in (2) above was subjected to a plasma treatment using a surface treatment plasma-generating apparatus (PR501A, commercially available from Yamato Kagaku Co., Japan) with an oxygen flow of 200 ml/min. and an output power of 50W for 30 seconds.

15 The total light transmittance of the thus treated article was 95.2%. The half life of the voltage of the electric charge was 10 seconds or less, and no punch dust was attached to the article in the punch dust test.

20 The fluorine/silicon (F/Si) ratio in the uppermost region of the top film was 0.05/1 by weight, while the average fluorine/silicon ratio in the entire top film was 0.07/1. The fluorine/silicon ratio in the uppermost region of the top film of the untreated article was 0.07/1 by weight.

25 Example 8

(1) Preparation of Transparent Lens

A diethyleneglycolbisallyl carbonate polymer lens

(diameter of 71 mm, thickness of 2.1 mm, CR-39 Planolens) with an index of refraction of 1.50 was dipped in an aqueous sodium hydroxide solution of a concentration of 20 wt % and washed. The lens was coated with the composition and the coating was cured as in Example 1 (4).

(2) Preparation of Anti-Reflection Optical Article

An anti-reflection optical article was prepared in the same manner as in Example 7-(2). The thus prepared article had the following properties:

Total Light Transmittance: 95.8%

Dyeability: 30%

Appearance after Dying: good

Steel Wool Hardness: A

(3) Anti-Static Treatment

The anti-reflection optical lens obtained in (2) was subjected to a plasma treatment in the same manner as in Example 7 (3).

The total light transmittance was 95.8%. The half life of the voltage of the electric charge was 10 seconds or less, and no punch dust was attached to the article in the punch dust test.

The fluorine/silicon (F/Si) ratio in the uppermost region of the top film was 0.05/1 by weight, while the average fluorine/silicon ratio in the entire top film was 0.07/1. The fluorine/silicon ratio in the uppermost region of the top film of the untreated article was

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0.07/1 by weight.

We claim:

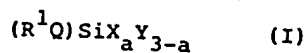
1. An anti-reflection optical article comprising:

a transparent plastic substrate;

5 a hard coat film formed on a surface of the substrate, the film having an index of refraction of not less than 1.52; and

a fluorine-containing organopolysiloxane-based film with a thickness of 10 nm to 500 nm, which has an index of refraction lower than that of the hard coat film by
10 not less than 0.02, and which is formed on the hard coat film.

2. The anti-reflection optical article of claim 1, wherein the fluorine-containing organopolysiloxane is a polymer of a fluorine-containing organic silicon compound
15 of the formula (I) and/or a hydrolysate thereof:



wherein R^1 is a $C_1 - C_{20}$ fluorine-containing alkyl group which may contain one or more ether bonds and/or ester bonds; Q is a divalent organic group; X is a $C_1 - C_4$
20 alkyl group; Y is a halogen, alkoxy or $RCOO^-$ group (wherein R is hydrogen or a $C_1 - C_4$ alkyl group); and a is an integer of 0 or 1.

3. The anti-reflection optical article of claim 1, wherein the content of the fluorine-containing
25 organopolysiloxane in the fluorine-containing organopolysiloxane-based film is not less than 10% by weight.

A. 4. The anti-reflection optical article of claim 1, 2 or 3,
wherein the hard coat film comprises inorganic oxide
microparticles.

5. The anti-reflection optical article of claim 4,
5 wherein the inorganic oxide microparticles comprise an
oxide of a metal selected from the group consisting of
antimony, titanium, zirconium and tantalum.

6. The anti-reflection optical article of claim 1, 2 or 3,
wherein the silicon to fluorine ratio by weight in the
10 entire fluorine-containing organopolysiloxane-based film
is 0.02 to 10, and the ratio in the uppermost region of
the fluorine-containing organopolysiloxane-based film is
less than 80% that of the entire fluorine-containing
organopolysiloxane-based film.

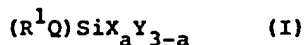
15 7. The anti-reflection optical article of claim 1, 2 or 3,
further comprising a second fluorine-containing
organopolysiloxane-based film with a thickness of 1 nm to
30 nm on the fluorine-containing organopolysiloxane-based
film, the second fluorine-containing
20 organopolysiloxane-based film having a fluorine to
silicon ratio by weight of less than 80% that of the
fluorine-containing organopolysiloxane-based film.

8. A process of producing the anti-reflection optical
article of claim 1, comprising the steps of:
25 providing the transparent plastic substrate on which
the hard coat film having an index of refraction of not
less than 1.52 is formed;

applying a liquid coating composition comprising a
fluorine-containing organic silicon compound and/or a
hydrolysate thereof, on the hard coat film; and

curing the applied composition to form the
5 fluorine-containing organopolysiloxane-based film with an
index of refraction lower than that of the hard coat film
by not less than 0.02.

9. The process of claim 8, wherein the
fluorine-containing organic silicon compound has the
10 formula:



wherein R^1 is a $C_1 - C_{20}$ fluorine-containing alkyl group
which may contain one or more ether bonds and/or ester
bonds; Q is a divalent organic group; X is a $C_1 - C_4$
15 alkyl group; Y is a halogen, alkoxy or $RCOO^-$ group
(wherein R is hydrogen or a $C_1 - C_4$ lower alkyl group);
and a is an integer of 0 or 1.

10. The process of claim 8, wherein the coating
composition further comprises a silica sol of a high
20 molecular weight silic acid in the form of a colloidal
dispersion.

11. A process of producing the anti-reflection optical
article of claim 6, comprising the steps of:

providing the transparent plastic substrate on which
25 the hard coat film having an index of refraction of not
less than 1.52 is formed;

applying a liquid coating composition comprising a

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fluorine-containing organic silicon compound and/or a hydrolysate thereof, on the hard coat film;

heating the applied composition to form the fluorine-containing organopolysiloxane-based film with an index of refraction lower than that of the hard coat film by not less than 0.02; and

subjecting the surface of the thus formed fluorine-containing organopolysiloxane-based film to an activated gas treatment.

12. The process of claim 11, wherein the activated gas treatment is a plasma treatment or a corona discharge treatment.

13. The anti-reflection optical article of claim 1, 2 or 3, which is a dyeable optical lense in which the hard coat film has a thickness of 0.5 μm to 20 μm and a pencil hardness of 4H or more and is made of an organic resin that optionally contains inorganic metal oxide microparticles having a mean particle size of 1 to 300 nm.

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